

5/46

DART AEROSPACE LTD	Work Order:	24712
Description: Bracket Assembly	Part Number:	D3303-043
Dwg: D3303 Rev. A	Qty:	5

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PF	05.10.26	5
2	GA	Assemble as per Dwg D3303 Pick: Qty Part Number Description Batch 1 D3303-1 Plate B22107 1 D3303-3 Bracket 8 MS20426AD3-3 Rivet 16 MS20470AD4-4 Rivet 4 MS21075L3 Nut Plate M18729 Identify as D3303-043	SP	06/03/10	5
3	QC5	Inspect work to Step 2	2	06.03.13	5
4	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 Mask threads prior to paint	DL	06/03/21	5
5	QC3	Inspect Powder Coat	M	06.03.21	5
6	ST	Identify and Stock st 381	PC	06/03/21	5
7	AC	Cost / part: _____	U	06.03.22	
8	DC	Close W/O Inspect Level 21	1	06.03.23	5

Rev	Date	Change	Revised By	Approved
A	04.09.07	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
11/04/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

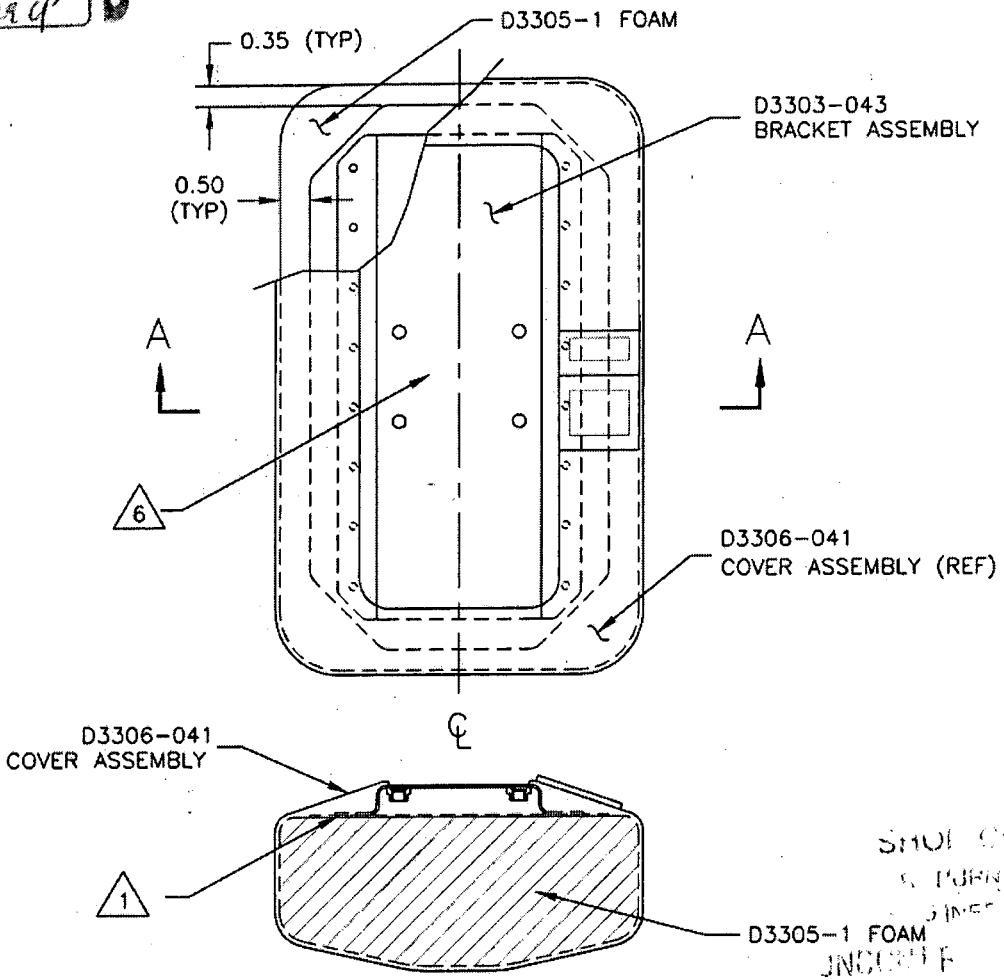
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

RELEASED
04.09.29 CP**SECTION A-A****D3303-041 HEAD REST**

WORI

NO 24712

D3303-041 NOTES:

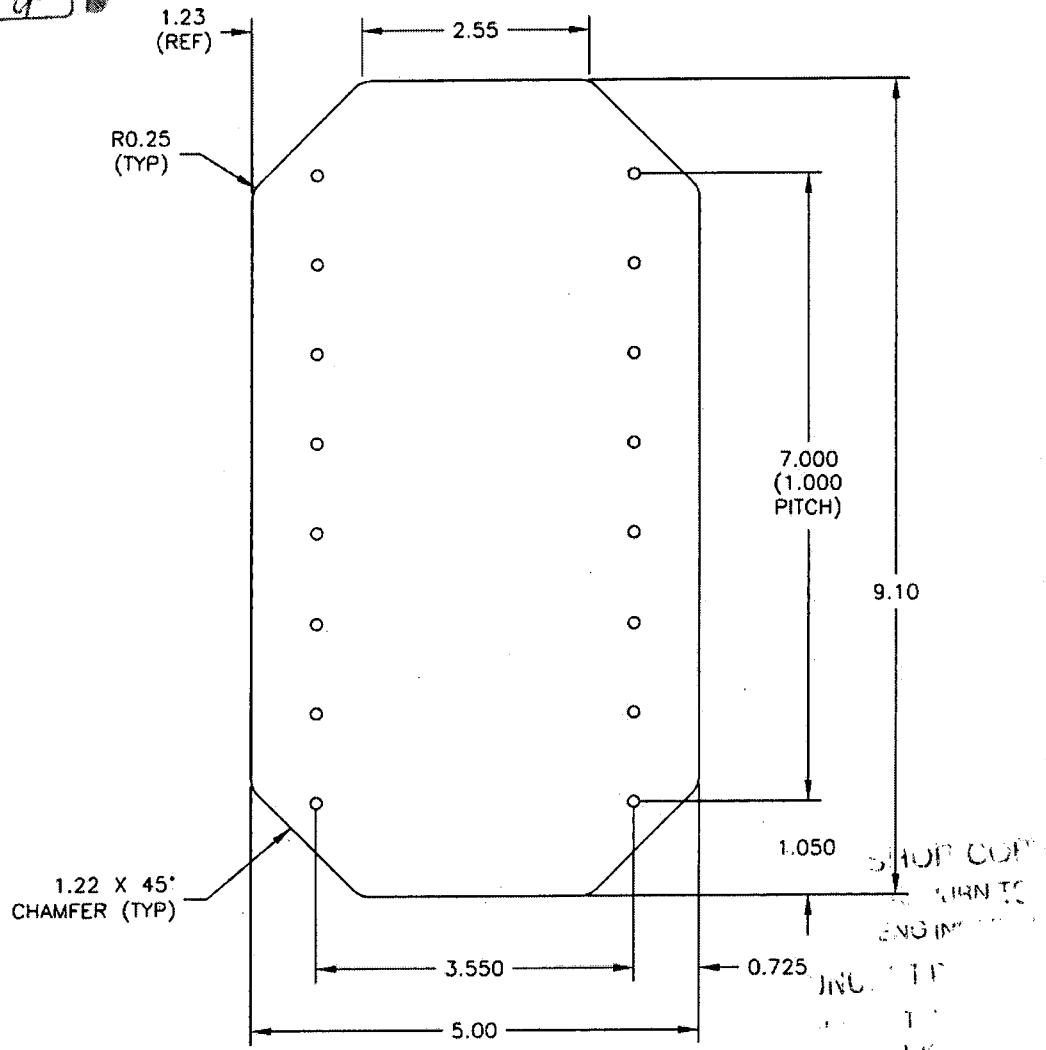
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

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DART

DESIGN <i>PF</i>	DRAWN BY <i>HF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>HF</i>	APPROVED <i>HF</i>	DRAWING NO. D3303
DATE 04.08.18		REV. A SHEET 3 OF 4 TITLE HEAD REST SCALE 1:2

RELEASED
04.09.29 UPD3303-1 PLATE

WORK

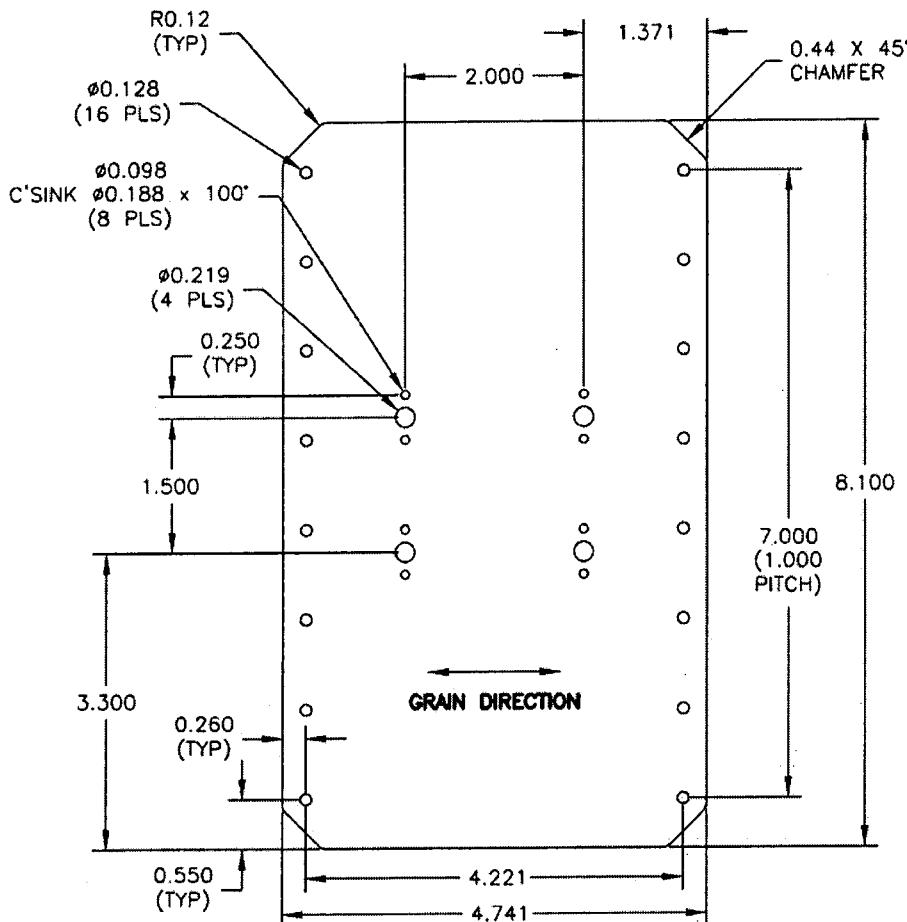
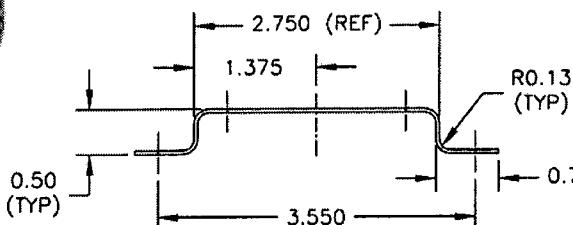
NO. 24712

D3303-1 NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**
04.09.29 CP**D3303-3 BRACKET
BEND DETAIL**SHEET 4 OF 4
RETURN TO
ENGINEERINGJNCONTR.
(SUBJECT TO
WITHDRAWAL)WORK C
NO. 24712**D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No : 0024712
 Project Name : D3303-043
 Project For : WK546
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3303-043
 Description : Bracket Assembly
 Manufactured : Yes
 Amount Req'd : 5
 Amount Done : 0
 Start Date : 10-26-05
 Est Finish Date : 11-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
HawkesburyNov 08, 2005
12:45 pm

Work Order No : 0024712
 Project Name : D3303-043
 Project For : WK546
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3303-043
 Description : Bracket Assembly
 Manufactured : Yes
 Amount Req'd : 5
 Amount Done : 0
 Start Date : 10-26-05
 Est Finish Date : 11-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Monday, 14/11/2005 3:52:17 PM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 24712		Part Number	: D3303043		
Estimate Number	: 10420		Drawing Number	: D3303 REV. A		
P.O. Number	:		Project Number	:		
This Issue	: 14/11/2005 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 30/11/2005 Qty: 5 Um: Each		
Previous Run	:					
Written By	:					
Checked & Approved By	:					
Comment	: Est: A 04.09.07 New Issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D33031	Plate
2.0	D33033	Bracket
3.0	MS20426AD33	Rivet
4.0	MS20470AD44	Rivet, Universal Head
5.0	MS21075L3	Nutplate
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Assemble as per Dwg D3303
- 2- Identify as D3303-043

7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

8.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3
 ****MASK THREADS PRIOR TO PAINT****

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT

10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

Date: Monday, 14/11/2005 3:52:17 PM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24712

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

